

Work Order ID 164415

164415

Page 1

Wednesday, July 19, 2017 10:29:42 AM

Item ID: D5123-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Clamp Cushion
 Start Date: 7/19/2017 Start Qty: 50.00 *50*
 Required Date: 7/28/2017 Req'd Qty: 50.00 *50*
 Reference:
 Cust Item ID:
 Customer:
 DAS 13 9-89 JUL 20 2017

Approvals: Process Plan: DAS 21 9-89 Date: JUL 19 2017 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D5123	D								

100 0.00
 100
 Purchasing
 Purchasing
 Memo
 ISSUE P/O: 37161
 SUPPLIER: GARLAND MANUFACTURING COMPANY
 MANUFACTURE AS PER DWG D5123-5
 C OF C IS REQUIRED
 100 JUL 20 2017 DAS 13 9-89

110 Receive & Inspect for Damage & Mat'l Certs 0.00
 110
 Packaging
 Packaging
 Memo
 100 AUG 16 2017 DAS 6 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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Required Date: 7/28/2017 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- All purchased or subcontracted products	0.00							
120									
QC	Memo	1.00							DAS 36 9-89
Quality Control									AUG 17 2017
130	Identify as per dwg & Stock Location L1259	0.00							
130									
Packaging	Memo	0.50							DAS 6 9-89
Packaging									AUG 17 2017
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	5.00							DAS 21 9-89
Quality Control									AUG 21 2017

UM 17/8/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Wednesday, July 19, 2017 10:29:45 AM

Page 1

Work Order ID: 164415

164415

Parent Item: D5123-5

D5123-5

Parent Item Name: Clamp Cushion

Start Date: 7/19/2017

Required Date: 7/28/2017

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP REV:A NEW ISSUE 14-08-28 VERIFIED BY:DD
REV:B 16-11-11 AS PER DWG REV.D DD VERF:JLM

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5123-5F *D5123-5F* Clamp Cushion		Purchased	No			100	Each	0.0000	1 **	50 100			

AUG 16 2017

DAS
6
8-89

DQA: _____ Date: _____

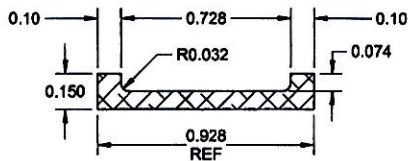


WORK ORDER NON-CONFORMANCE / UPDATE

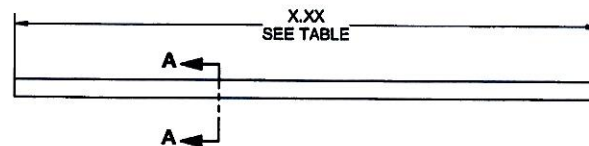
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

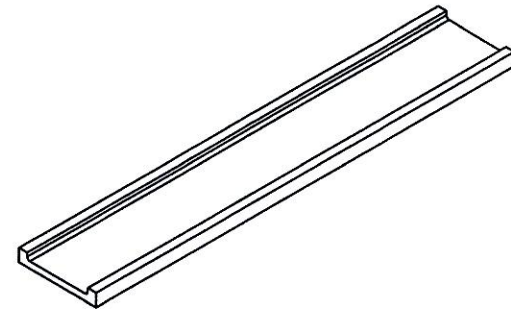


SECTION A-A
SCALE 2X



D5123-Y CLAMP CUSHION

PART NUMBER	LENGTH X.XX (IN)
D5123-1	5.00
D5123-3	4.25
D5123-5	6.00
D5123-7	3.95



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 164415 M.C.5
1707-19

NOTES:

- 1) MATERIAL: MAKE FROM D4287-1 OR VIRGIN GAR-DUR UHMW-PE, NATURAL, (GARLAND MANUFACTURING COMPANY)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.7
- 7) WEIGHT: LESS THAN 0.01 lbs

RELEASED
2016-11-09
EN 16-589

APPROVED

D	ADD PURCHASE OPTION- NEW SUPPLIER REASON: CIR16-69	DB	16.05.09
C	ADD D5123-7	CP	15.01.21
B	ADDED D5123-5 CLAMP CUSHION, ADDED TABLE, ADDED THICKNESS TO PART	AP	14.08.19
A	NEW ISSUE	AP	14.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	DD	D5123	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	CLAMP CUSHION	NTS
DATE	16.05.09	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



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OTHER : ☐					



GARLAND MANUFACTURING
COMPANY
55 INDUSTRIAL PARK RD
SACO ME 04072
USA

Quality certificate

Quality certificate number

0316746/2017

Date

05/31/2017

Order / Date

26088 / 05/30/2017

Delivery item/date

802333603 000010 / 05/31/2017

Order item/date

4493148 000010 / 05/30/2017

Customer

3000003954

Invoice

Truck ID

356

Material code
UTEC6540G-UHMWPE

Lot (batch): BADA FH137E / Validity: 02/21/2019
Quantity: 49,580.000 LB / Production Date: 08/25/2016

Property	Unity	Result	Min Value	Max Value	Method.
Molecular Weight (10^6 g/mol)	g/mol	7.6	6.8	9.7	
Bulk Density	g/cm ³	0.45	0.43	0.50	ASTM D 1895-03
Average Particle Size	μ m	229	205	245	ASTM D 1921
I.V. Average	dL/g	28.0	26.0	33.0	ASTM D 4020-05

We confirm the supply as requested
Quality Control Manager: Natanael Carreira
CRQ nº 04200878 / 4ª Region

For any questions about our products, please e-mail to pe-pp@braskem.com.br.

This certificate is automatically printed and is valid without signature



Industrial Plastics
Ultra-High Molecular Weight Polyethylene

55 Industrial Park Road
POB 538
Saco, Maine 04072

Specialty Striking Tools
Garland Rawhide Hammers & Mallets

PH: 207/283-3693
FX: 207/283-4834
<http://www.garlandmfg.com>

Dart Aerospace
Attn: Linda Lacelle
1270 Aberdeen St.
Hawkesbury, ON K6A1K7
Re: Quality Clauses A017 and A026
Date: August 11, 2017

Linda:

A026

Please be advised that Garland Manufacturing, located in Saco, Maine, USA, hereby certifies that the material provided by this company for your PO 37161 meets or exceeds ASTM Specification D-4020-05a, the current ASTM specification for Ultra-High Molecular Weight Polyethylene; also known as UHMW or UHWM-PE. Garland Mfg. Company only processes UHMW-PE material at the upper end of the molecular weight range. Our virgin GAR-DUR® UHMW plastic is made from resin with an I.V. of 24 and above with a minimum molecular weight of 4.2 million.

A017

Your parts were produced from the following Resin Lot:

Braskem UTEC6540G resin lot # BADAFH137E, See attached Quality Certificate
#0316746/2017/2016

Best Regards,

James Garland
Garland Manufacturing Company
jgarland@garlandmfg.com
800/727-1900 x 45



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO37161

Purchase Order Date 7/20/2017

PO Print Date 7/20/2017

Page Number 1 of 2

Order From :
GARLAND MANUFACTURING CO.
P.O. BOX 538
SACO, MAINE 04072
USA

VU-GMC01

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

JUL 20 2017

Contact Name
Vendor Phone 207-283-3693

Ship To Contact
Ship To Phone

Ship Via: FedEx Economy collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	E:
Line Comments			Promise Date				
Delivery Comments							
1	D5123-5F	Clamp Cushion	8/30/2017 Yes 8/30/2017	FN	100.00 Each	\$1.35	
AS PER DWG D5123 REV. D B164415							
						Line Total:	
2	71401-45	PROCUREMENT QUALITY CLAUSES	8/30/2017 No 8/30/2017		1.00	\$0.00	
PROCUREMENT QUALITY CLAUSES A005 RIGHT OF ENTRY A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER A016 PERSONNEL QUALIFICATION A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE) A026 CERTIFICATION OF MATERIAL CONFORMANCE A041 QUALITY MANAGEMENT SYSTEM A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENT							

AUG 16 2017

AUG 16 2017

046
38
-89

Note:

7/20/2017

GARLAND MFG COMPANY
P.O. BOX 538
SACO, ME 04072
(207) 283-3693

GAR-DUR PLASTIC

RAWHIDE
MALLET AND HAMMERS

Shop Floor Copy

Order Number: 0186901
Order Date: 7/21/2017
Salesperson: 71F

Customer Number: 30-0615903

Sold To:
DART AEROSPACE OEM
1270 ABERDEEN STREET
HAWKESBURY, ON K6A1K7
Confirm To:

Ship To:
DART AEROSPACE OEM
1270 ABERDEEN STREET
HAWKESBURY, ON K6A1K7

Customer P.O.	Ship VIA	Requested Date	Terms
PO37161	UPS COLLECT	8/23/2017	See FD
	6645W1		
Product Code	Description	Units	UOM
310001	FABRICATED PART	100.00	EACH

TO DWG: D5123 REV D
PN: D5123-5F
CLAMP CUSHION
MAIL
PROCUREMENT CLAUSES: A005, A007, A016, A017, A026
A041, A042, A043

AUG 16 2017

Approx WT: 0.00			
Date Shipped	BDL or Carton	Weight	Quantity
8/16/17	1		100

DAS
38
39



Garland Manufacturing Company

Industrial Plastics
Ultra-High Molecular Weight Polyethylene

55 Industrial Park Road
POB 538
Saco, Maine 04072

Specialty Striking Tools
Garland Rawhide Hammers & Mallets

PH: 207/283-3693
FX: 207/283-4834
<http://www.garlandmfg.com>

Dart Aerospace
Attn: Linda Lacelle
1270 Aberdeen St.
Hawkesbury, ON K6A1K7
Re: Quality Clauses A017 and A026
Date: August 11, 2017

Linda:

A026

Please be advised that Garland Manufacturing, located in Saco, Maine, USA, hereby certifies that the material provided by this company for your PO 37161 meets or exceeds ASTM Specification D-4020-05a, the current ASTM specification for Ultra-High Molecular Weight Polyethylene; also known as UHMW or UHWM-PE. Garland Mfg. Company only processes UHMW-PE material at the upper end of the molecular weight range. Our virgin GAR-DUR® UHMW plastic is made from resin with an I.V. of 24 and above with a minimum molecular weight of 4.2 million.

A017

Your parts were produced from the following Resin Lot:

Braskem UTEC6540G resin lot # BADA FH137E, See attached Quality Certificate
#0316746/2017/2016

Best Regards,

James Garland
Garland Manufacturing Company
jgarland@garlandmfg.com
800/727-1900 x 45



GARLAND MANUFACTURING
COMPANY
55 INDUSTRIAL PARK RD
SACO ME 04072
USA

Quality certificate

Quality certificate number

0316746/2017

Date

05/31/2017

Order / Date

26088 / 05/30/2017

Delivery item/date

802333603 000010 / 05/31/2017

Order item/date

4493148 000010 / 05/30/2017

Customer

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Truck ID

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Material code
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I.V. Average	dL/g	28.0	26.0	33.0	ASTM D 4020-05

We confirm the supply as requested
Quality Control Manager: Natanael Carreira
CRQ nº 04200878 / 4ª Region

For any questions about our products, please e-mail to pe-pp@braskem.com.br.

This certificate is automatically printed and is valid without signature

Invoice

Page 1

FROM Tax ID/EIN/VAT No.: Contact Name: Mal Parsons Garland Mfg 55 Ind'l Park Rd Saco, ME 040721804 United States Phone: 2072833693		Waybill Number: 1Z0194446857581346 Shipment ID: 019444KNNYR  Date: 11/AUG/2017 Invoice No.: PO 37161 Purchase No.: 186901 Terms of Sale (Incoterm): Reason for Export: Sale	
SHIP TO Tax ID/VAT No.: Contact Name: ATTN: LINDA LACELLE DART AEROSPACE 1270 ABERDEEN ST HAWKESBURY, ON K6A1K7 Canada Phone: 6136322577		SOLD TO INFORMATION Tax ID/VAT No.: Contact Name: Same as Ship To Phone:	

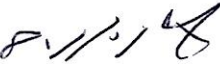
Units	U/M	Description of Goods/Part No.	Harm. Code	C/O	Unit Value	Total Value
	100 NMB	D5123-5F 310001	392190	US	1.35	135.00 USD

Additional Comments:

Declaration Statement:

I hereby certify that the information on this invoice is true and correct and the contents and value of this shipment is as stated above.


 Shipper


 Date

Invoice Line Total:	135.00
Discount/Rebate:	0.00
Invoice Sub-Total:	135.00
Freight:	0.00
Insurance:	0.00
Other:	0.00
Total Invoice Amount:	135.00

Total Number of Packages: 1 **Currency:** USD
Total Weight: 3.5 LBS

These items are controlled by the U.S. Government and authorized for export only to the country of ultimate destination for use by the ultimate consignee or end-user(s) herein identified. They may not be resold, transferred, or otherwise disposed of, to any other country or to any person other than the authorized ultimate consignee or end-user(s), either in their original form or after being incorporated into other items, without first obtaining approval from the U.S. government or as otherwise authorized by U.S. law and regulations.